



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A94-3700-A
Job Sheet 170583



Part No: RBE350A94 3700-A

Job Qty: 6 ea ²¹₉₋₈₀

Part Name: Swashplate Immobilizing Tool Long Brace



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/27/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-3700-A Rev 7 IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	2/27/18	2/27/18	0.00	0.00	Start Up Small Fab-4		
110	Small Fab	6 pcs	2/27/18	2/27/18	0.00	0.60	Small Fab-4		
120	QC	6 pcs	2/27/18	2/27/18	0.00	0.00	QC5		
130	Packaging	6 pcs	2/27/18	2/27/18	0.00	0.00	Packaging3-1		
140	QC21-FG	6 Ea	2/27/18	2/27/18	0.00	0.00	QC21		

Part Op
Descriptions: 110 - Pick, bag and tag.

²¹₉₋₈₀ APR 04 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE350A94-3700-A-1A	Long Brace Assembly	18 Ea (3 ea)	90-Start up Operation	5056140

Part Specifications

Specifications could not be found.

Plex 1/17/18 11:28 AM Dart.lajeunesse.marie

DML 3-29



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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S056253



Part: RBE350A94-3700-A

Job No: 170583

Serial No/Batch: S056253

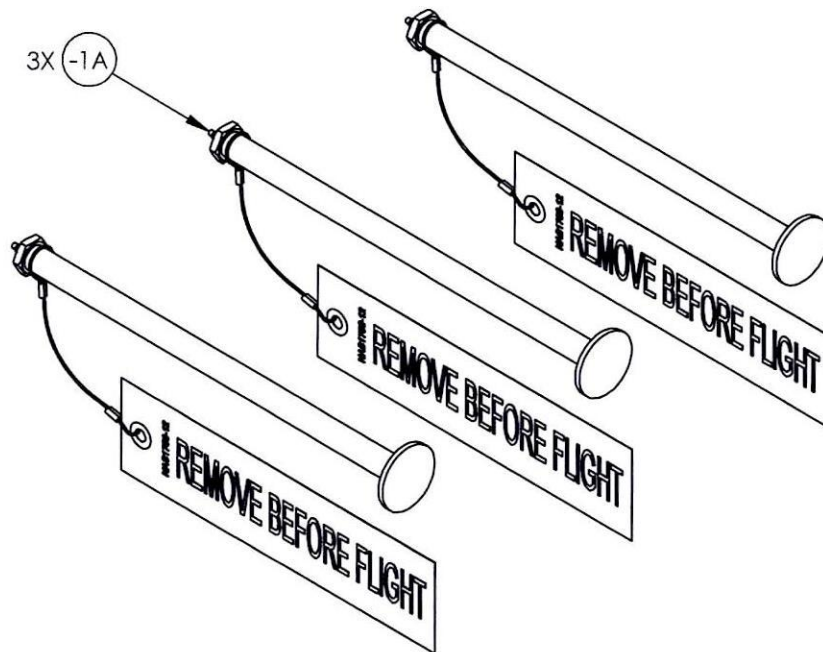
Revision: 7

Inspector:

Date: 03/29/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		BROKE OUT FROM KIT AS INDIVIDUAL TOOL.	8/21/2012	RJC	RW
5		-03 ADDED P.F. -01 TO CAP PIN. -05 ADDED P.F. -01 TO FOOT PIN DIAMETER.	4/17/2013	CFS	GE
5A		CH'D T/N WAS RBEA94-3700-A IS RBE350A94-3700-A, DELETED ASSY. FROM TOOL NAME.	10/23/2013	CFS	RW
6	15-0212	-A DELETED ENGRAVE NOTE, CHD DIM WAS 14.60 IS 14.60 ±.02. -01 CHD OAL WAS 14.173 IS 14.164. ADDED ENGRAVE NOTE.	8/14/2015	RJC	JAG
7	16-0282	ADDED USED IN KITS NOTE. -1A ADDED TO BOM QTY: 3. ADDED DRAWING. -01, -03, -05 ADDED FINISH BLACK OXIDE QMSH-6.2.2, B.O. REV D. -01 ADDED DIMS Ø.6040-.6047 (P.F. -03), .88, Ø.6040-.6047 (P.F. -05), .88. CH'D MATL WAS STEEL IS DOM. -03 CH'D DIMS WAS .04 IS 2X .04, WAS P.F. -01 IS Ø.6052-.6056 (P.F. -01), -05 CH'D DIM WAS P.F. -01 IS Ø.6052-.6056 (P.F. -01), CH'D MATL WAS 1018/1020 IS 1018/1020 CR. -09 QTY: 1, -11 QTY: 1, -13 QTY: 2 ADDED TO -1A ASSY.	1/3/2017	DPD	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170583 MJS
18-01-18

NOTES:

- CROSS REFERENCE No.'S
RED BARN No.'S + HELIPRODUCTS No.'S
RBE350A94-3700-A-01 = E-350A94-3700-40
RBE350A94-3700-A-03 = E-350A94-3700-22
RBE350A94-3700-A-05 = E-350A94-3700-21
FOR REFERENCE ONLY
- USED IN KITS:
RBE350A94-2700-05
RBEA62309

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1A	3	LONG BRACE ASSEMBLY			2
	1		-01		TUBE	DOM		3
	1		-03		CAP	SP		4
	1		-05		FOOT	1018/1020 CR		5
	1	B/O	-07		EXTENDED POINT SET SCREW, DOG POINT	STEEL	M6 X 1 X 30mm (MCMaster-CARRER #92905A225)	2
	1	B/O	-09		REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	2
	1	B/O	-11		LANYARD	COATED STEEL	Ø1/16 X 14 (CARR LANE #CL-2-C)	2
	2	B/O	-13		FERRULE	ALUMINIUM	Ø1/16 X 3/8 (MCMaster-CARR #3896T31)	2
	ASSY -1A							

		TITLE		SWASHPLATE IMMOBILIZING TOOL LONG BRACE	
		DWG NO.		RBE350A94-3700-A	
REV		7			
MAT'L		UNLESS OTHERWISE SPECIFIED		DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .005		FRACTIONS ± 1/8	
FINISH		.XX ± .01		ANGLES ± 5°	
SPEC		.X ± .1		SURFACES = 125/	
DRAWN BY:		CLOUGH		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED:		MACKOVJAK		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR:		ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR:		LINDSAY		USED ON MODEL	
APPROVED:		GILBERT		EUROCOPTER AS350/355	
SCALE		1:5		DATE 8/21/2012	
				SHEET 1 OF 5	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																													
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